



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V3021225
Job Sheet 180242



Part No: RBEM632V3021225

Job Qty: 6 ea

Part Name: Counter Key



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/3/18

Job Tracking No:

Due Date: 8/13/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3021225 Rev. 2 IPP Rev. A 18.06.27 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	6 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Machining-4		<i>18/10/18</i>
110	Mori Seiki	6 pcs	8/13/18	8/13/18	0.00	6.00	MORI SL-154		<i>18/10/18</i>
120	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC2 Machining-5		<i>18/10/18</i>
130	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC8 Machining-5		<i>18-10-07</i>
140	Small Fab	6 pcs	8/13/18	8/13/18	0.00	1.50	Small Fab-2		<i>18-10-07</i>
150	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>13</i>
160	Outsource	6 pcs	8/13/18	8/13/18	0.00	0.00	Outsource1 (Atlantic)		<i>13</i>
170	Outsource	6 pcs	8/13/18	8/13/18	0.00	0.00	Outsource13		<i>9-89</i>
180	Packaging	6 pcs	8/13/18	8/13/18	0.00	0.00	Packaging2		<i>18 OCT 23 2018</i>
190	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC6		<i>68</i>
200	Powdercoat	6 pcs	8/13/18	8/13/18	0.00	0.60	Powdercoat13		<i>18 OCT 23 2018</i>
210	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC3		<i>18 OCT 23 2018</i>
220	Small Fab	6 pcs	8/13/18	8/13/18	0.00	0.60	Small Fab-1		<i>18 OCT 23 2018</i>
230	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>18 OCT 23 2018</i>
240	Packaging	6 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3		<i>18 OCT 23 2018</i>
250	QC21-FG	6 Ea	8/13/18	8/13/18	0.00	0.00	QC21		<i>18 OCT 23 2018</i>

Part Op 110 - 1-Machine as per folio FC216 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 140 - Broach as per DWG. *Atlantic*

160 - 1-Issue P/O to METCORE; P/O _____ RC 34-40 2-Bead blast ***NOTE*** do not bead blast threads. 3-Material type; O1 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH*** *Atlantic*

170 - 1-Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; O1 -Certificate of Conformity is required

200 - START TIME: *8:45* OVEN TEMPERATURE: *320°* FINISH TIME: *9:15* No powder coat at this location as per note 4. *M 138677.*

220 - Laser engrave T/N as per DWG.

Job BOM

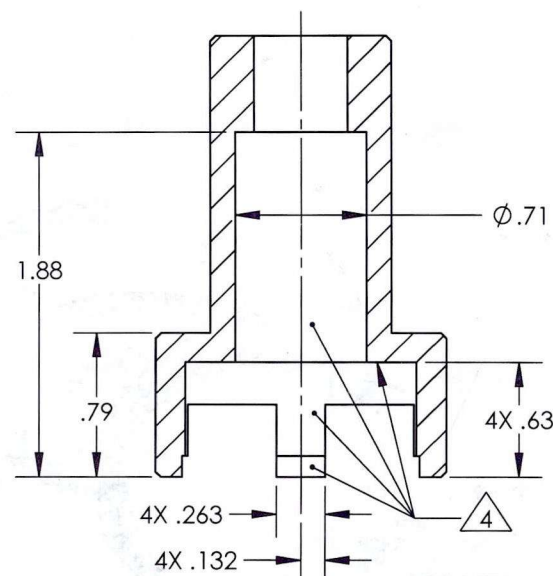
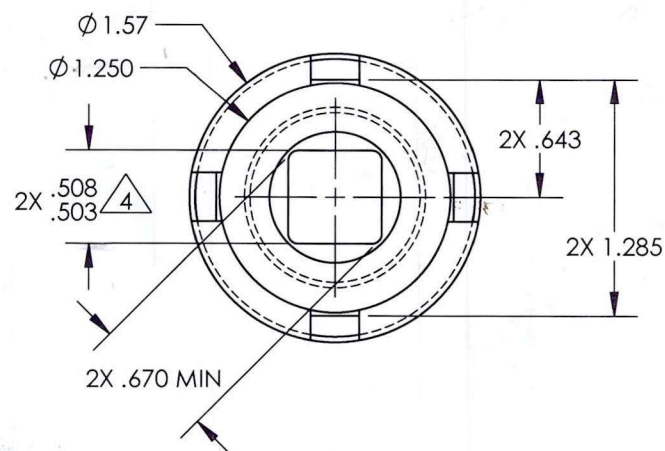
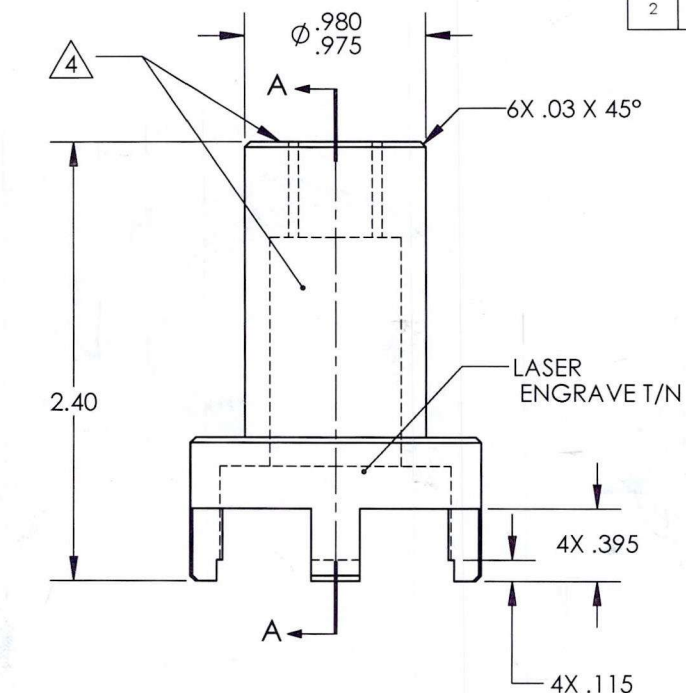
Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R1.750	Tool Steel Round Bar 1.750 dia.	1.2960 ft (.216 ea)	100-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	MT-O1-R1.750	1	11	0
Part Specifications				
Specifications could not be found.				

Plex 10/3/18 2:52 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	8/12/2016	SM	JAG
2	17-0017	ADDED TWO MORE PLACES FOR NO POWDER COAT. CH'D DIM WAS Ø.980/.975△ IS Ø.980/.975. CH'D PART MARK WAS INK STAMP T/N IS LASER ENGRAVE T/N.	4/14/2017	RJC	JAG



SECTION A-A

NOTES:

1. REF. AIRBUS T/N: M632V3021225.
2. USED IN KIT RBEM632V3021102.
3. MULTI FINISH:
 1. ZINC PLATE SPEC ASTM B633 TYPE 1 SC2.
 2. POWDERCOAT YELLOW SPEC FED # 13538.

Δ NO POWDER COAT ON SURFACE.

DART AEROSPACE	
TITLE COUNTER KEY	
DWG NO. RBEM632V3021225	REV 2
MAT'L O1 HEAT TREAT HRC 34-40 FINISH SEE NOTES SPEC DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL H175	
SCALE 1:1	DATE 3/3/2016
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	COUNTER KEY	O1		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S116367



Part: RBEM632V3021225

Job No: 180242

Serial No/Batch: S116367

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 10/05/18

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation			Disposition			Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	

FAULT CATEGORY		
☐ Power Loss/Surge	☐ Positioned Wrong	
☐ Folio/Program	☐ Outside Dimensions	
☐ Grain	☐ Over/Under tolerance	
☐ Weld	☐ Part Incorrect	
☐ Wrong Stock Pulled	☐ Part Lost/Missing	
☐ Out of Sequence	☐ Part Moved	
☐ Off-set	☐ Drawing	
☐ Misabeled	☐ Finish	
☐ Fit/Function	☐ Misread	
☐ Misaligned/off center	☐ Turning Sequence	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041282**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041282
PO Date: 10/9/18
Due Date: 10/18/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180242	RBEM632V3021225	Counter Key 1-Issue P/O to ATLANTIC; P/O RC 34-40 2-Bead blast ***NOTE*** do not bead blast threads. 3-Material type; O1 4- Certificate of Conformity is required 1-Issue P/O to METCORE; P/O RC 34-40 2-Bead blast ***NOTE*** do not bead blast threads. 3-Material type; O1 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH***	Firmed	-	10/18/18	6 pcs	0 pcs	6 pcs	\$10.85/pcs	\$65.10
2	181298	C10-4	Lock 1-Issue P/O to ATLANTIC; P/O RC 40-44 2-Bead blast 3- Certificate of Conformity is required	Firmed	-	10/18/18	10 pcs	0 pcs	10 pcs	\$17.00/pcs	\$170.00

6x

OCT 18 2018

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10x

OCT 18 2018

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041282**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$235.10

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL

Plex 10/18/18 12:24 PM dart.lavoie.chantal

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 156446
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041282 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
----------	---	--------

✓ 6PCS MATERIAL 01

SAND BLAST AND HEAT TREAT TO 34-40RC

C OF C, PRT# RBEM632V3021225, JOB# 180242 ✓

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

Pounds Shipped:

6

2.00

39RC

10.15.18

Order No.: 159314

Shipped Complete

Quantity Shipped:

6.00

Received By:

Date:

Pounds Shipped:

2.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 10/12/2018

Certification

Date: 10/15/2018

Entry Date: 10/12/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041282

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6PCS MATERIAL 01 SAND BLAST AND HEAT TREAT TO 34-40RC C OF C, PRT# RBEM632V3021225, JOB# 180242	2

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 34. 40. 39. TESTED AS PER SAMPLING PLAN

HARDEN & SANDBLAST TO 39 RC AS PER CUSTOMER'S REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEANE SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041385**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041385

PO Date: 10/19/18

Due Date: 10/24/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED

OCT 22 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180242	RBEM632V3021225	Counter Key -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; O1 -Certificate of Conformity is required	Firmed	-	10/24/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00

6X

OCT 23 2018

[Signature]

Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

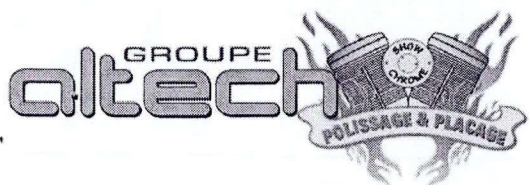
A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Signature]

Plex 10/22/18 10:36 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(013711-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013711 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Oct-2018		Aman		041385 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM632V3021225 ✓ Rev.	RBEM632V3021225 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2 ASTM B633 0.0003 THICK	ZINC CH	6 ✓	6	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.